

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021029**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12BE to 12CE ,UT repair weld No. OBE12E-003. The welder is identified as #040403. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR-FCM-1. The weld repair report is identified as CWR2812.The welding variables were recorded at, Amperage 157, volts 24.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12CE ,UT repair weld No. SEG3003A-012. The welder is identified as #040403. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR-FCM-1. The weld repair report is identified as CWR2814.The welding variables were recorded at, Amperage 135, volts 24.7.The In-process SMAW appears to be progressing in compliance with approved contract documents.

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## WELDING INSPECTION REPORT

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SMAW in the 4F position for the OBG Segment 12BW , weld No.LD3021-001-059. The welder is identified as #057333. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply WPS-B-P-2114-FCM-1. The welding variables were recorded at, Amperage 138, volts 23.5.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for the OBG Segment 12BW to 12CW, UT repair weld No.OBW12E-001. The welder is identified as #040611. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply WPS-345-SMAW-4G(4F)-REPAIR-FCM-1. The weld repair report is identified as WR20193.The welding variables were recorded at, Amperage 152, volts 24.3.The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for the OBG Segment 12BW to 12CW, UT repair weld No.CA3009-005. The welder is identified as #046709. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply WPS-345-SMAW-2G(2F)-REPAIR-FCM-1. The weld repair report is identified as WR20285.The welding variables were recorded at, Amperage 168, volts 24.7.The In-process SMAW appears to be progressing in compliance with approved contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**The ABF QA inspector performed D-Scan Ultrasonic Testing for splice joint joining between bottom plate to bottom plate at segment 12BW to 12CW at trial assembly area**



**ZPMC personnel performing SMAW for UT repair splice weld joint OBE12E-003 at 4G position on side plate of segment 12BE to 12CE at Trial Assembly area**



### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Bera,Subhasis

Quality Assurance Inspector

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**Reviewed By:** Dsouza,Christopher

QA Reviewer